

ABSTRACT OF THE DISCLOSURE

A pair of easy to install universal cargo tie-down rails for mounting on a variety of station wagon or van roof panels and on pick-up truck cargo boxes and a method. Each of the tie-down rails is comprised of a pair of end brackets, at least one intermediate bracket, a cylindrical thin wall tube and small fasteners in each of the brackets for clamping the brackets on the thin wall tube. Each of the brackets is slidably mounted on the thin wall tube and free to rotate about the axis of the cylindrical tube before the bracket is clamped to the tube. In an alternate embodiment, the ends of the tube are closed with pressed in place covers. The method of making the tie-down brackets includes the steps of extruding an aluminum billet through a die to form an extrusion blank, cutting specified lengths from the extrusion blank to correspond to the widths of the brackets, drilling and tapping holes in the cut portions of the extrusion blank, applying a finish to the cut portions to complete the brackets, cutting specified lengths of a thin wall tube, assembling the finished brackets to the cut length of the tube, engaging and threadably tightening the small fasteners in the brackets to clamp the brackets to the cut length of tube.